

Date: Thursday, 5/24/2007 10:36:58 AM
 User: Eric Charbonneau

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 00082A
 Estimate Number : 10068
 P.O. Number :
 This Issue : 5/24/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D LG FAB
 Previous Run : 00081A

Drawing Name

: INITIAL PROTOTYPE TEMPLATE

03564-5, Rev C

RH

: INITIAL PROTOTYPE

07.06.05

Part Number

Drawing Number

Project Number : WP0002

Drawing Revision

Material

Due Date

: 9/25/2006

Qty:

1 Um:

Each

Written By :
 Checked & Approved By :
 Comment : Project #: _____
 Description: _____

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

- Cut as per Dwg 03564 prot. ml 10/18/03
- QC 2 ml 07/05/05
- QC 8
- Band SSB 07/05/30
- To be kept in engineering lab.
- RH
- 07.06.05

2.0

PG

PURCHASING



Comment: PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

C'd 07/06/06

QC 21 final inspection w/o release

07/06/06

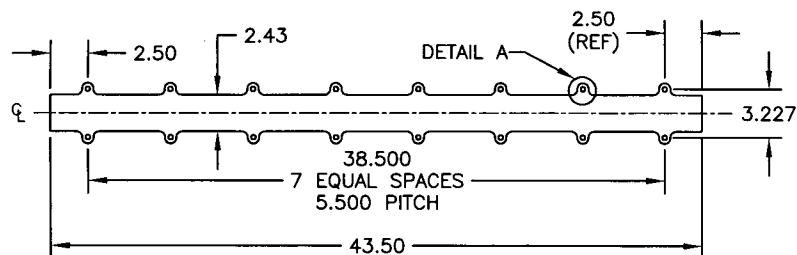
Job/Project Number: 00082

Design Engineer/Project Manager Signature: PH Date: 07.05.24

Design Manager Signature: Date:

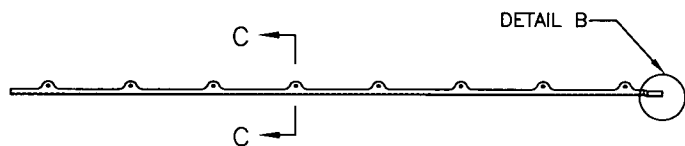
PROTOTYPE REQUEST FORM

Item	Part Number	Drawing Number Date	Qty	Material Cert Required (Y/N)	Due Date	Complete Date	Comments
1	D3564-5	D3564, REV C, DATED 07.04.17, PRELIMINARY	1	N	07.05.24	07.06.05 RL	WATERJET AND BEND ONLY, NO PAINT, RETURN TO PH

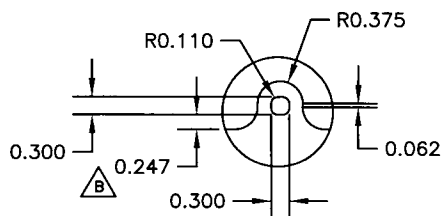


D3564-5F FLAT PATTERN

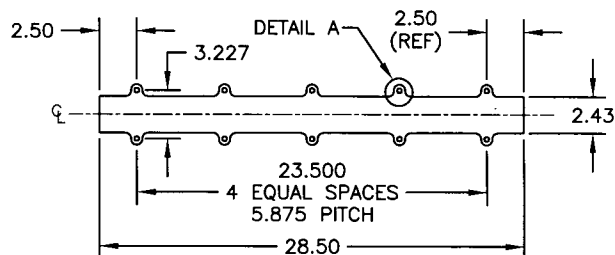
THIS
ONE ONLY



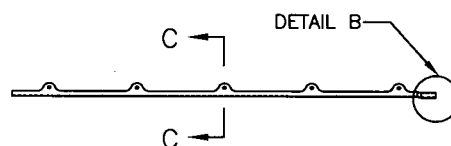
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



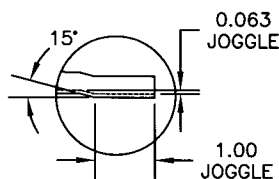
DETAIL A
SCALE 1:2



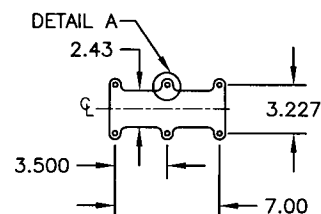
D3564-7F FLAT PATTERN



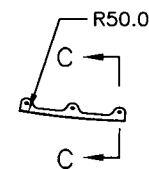
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



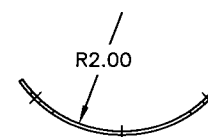
DETAIL B
SCALE 1:2



D3564-13F FLAT PATTERN



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



SECTION C-C
SCALE 1:2

PRELIMINARY ISSUE
07.05.24 PH

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DATE 07.04.17		TITLE WEARSHOE		SCALE 1:8	

MATERIAL: A151 304/316 16 GAUGE (0.063 THICK)
(M304S16GA)

DART AEROSPACE LTD		Work Order: 00082A
Description: Beapaw Initial Prototype Template		Part Number: Prototype
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.300	+/-0.010	0.300	✓		vern	
B 0.300	+/-0.010	0.300	✓		vern	
C 43.50	+/-0.030	43.50	✓		measuring tape	
D 3.221	+/-0.010	3.230	✓		vern	
E 2.43	+/-0.030	2.436	✓		vern	
F 5.500	+/-0.010	5.506	✓		vern	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MM</i>	Audited by:	Prototype Approval:	N/A
Date: 070525	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	



NORTH AMERICAN STAINLESS CANADA, INC.

Call Center: 551 2 Mail Box

Box 201

METALLURGICAL TEST REPORT
18 MAR 2006
NORTH AMERICAN STAINLESS CANADA
740 IMPERIAL ROAD NORTH
GUELPH, ON N1K1Z3

CUSTOMER: 007035 002

Steel: 304

Finish: 2B

Date: 3/15/2006 Page: 1

Your Order: 75-02485

Has Order: EN 0000217 02

PRODUCT DESCRIPTION

REMARKS:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTM A240/05A, 480/05, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q8676D-A X NO ENH, AMES 131 X HICKS, MIL 5059D, AHD1, X CHAM HESS
Material free from mercury contamination. No weld repairs.
EN 10204 3.1 END 97/23/EC Annex 1, Para. 6.3 Q86763P Cond A
Material is ROHS-Compliant

Corrosion: ASTM A262/02A1, 100hrnd-CX

Product ID	Coil #	Thickness	Width	Weight	Length	Mark	Place	Commodity Code
0391M2 A		.0575	48.0000	15.420	COIL			

CHEMICAL ANALYSIS

CM(Country of Mfg) ES(Spec) US(United States)

Heat	CM	C	CH	CU	MM	MO	N	NI	P	S	SI
91M2	US	.056	18.008	.302	1.709	.258	.067	8.151	.027	>	.001 .325

MECHANICAL PROPERTIES

Product ID	Coil #	1 d	0.1	0.2	UTS	.2% YS	ELONG	RD	Hard
0391M2 A					93.65	42.28	56.14	81.50	86.00

RECEIVED
18 MAR 16 2006

BY

QC ENGINEER

ERIC HESS

3/15/2006